

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016085**Date Inspected:** 09-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li yang.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG Trial Assembly Yard:

This QA Inspector observed the following work in progress:

Cross Beam 11 (CB11):

The Shielded Metal Arc Welding (SMAW) process on weld joint no: CB202A-011-013 and 015. The welder's were identified as 205718 and 045268 and were observed welding in the 4G position. ZPMC Quality Control (QC) was identified as Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1.

OBG Seg 9BW:

The SMAW process on weld joint no: SSD10A-PP74-170. The welder is identified as 045268 and was observed welding in the 4G position. ZPMC QC was identified as Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1.

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OBG Seg 9DW and Seg 9EW:

The SMAW process on weld joint no: OBW9C-008. The welder is identified as 067610 and was observed welding in the 4G position. ZPMC QC was identified as Zhong Peng. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

The SMAW process on weld joint no: OBW9C-006. The welder is identified as 067764 and was observed welding in the 4G position. ZPMC QC was identified as Zhong Peng. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

The SMAW process on weld joint no's: CA065-006 and CA067-002. The welder is identified as 037932 and was observed welding in the 4G position. ZPMC QC was identified as Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1. See attached photo for further details.

OBG Seg 9AW:

The SMAW process on weld joint no: OBW9K-002. The welder's are identified as 069896 and 067904 and were observed welding in the 4G position. ZPMC QC was identified as Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1. See attached photo for further details.

OBG Seg 9CW:

The SMAW process on weld joint no: OBW9K-008. The welder's are identified as 068917 and 067829 and were observed welding in the 4G position. ZPMC QC was identified as Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1. See attached photo for further details.

OBG Seg 9DW:

The SMAW process on weld joint no: OBW9K-010. The welder's are identified as 067609, 067572 and 066258 and were observed welding in the 4G position. ZPMC QC was identified as Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1. See attached photo for further details.

OBG Seg 9BW and Seg 9CW:

Notification no: 006366.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC QC personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

- 1) DP684-001-017 and 018.
- 2) DP685-001-011 and 012.
- 3) EP126-002-017 and 018.
- 4) EP127-001-005 and 006.

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- 5) SP670-002-063, 064, 069 and 070.
- 6) SP671-001-013, 014, 019 and 020.
- 7) SP492-002-063 and 064.
- 8) SP493-001-007 and 008.
- 9) SP730-002-049 and 050.
- 10) SP731-001-001 and 002.
- 11) SP770-002-031 and 032.
- 12) SP771-001-007 and 008.
- 13) BP-152-001-047 and 048.
- 14) BP153-001-035 and 036.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No significant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

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**Inspected By:** Wadkar,Sailesh

Quality Assurance Inspector

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**Reviewed By:** Peterson,Art

QA Reviewer

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